








Work Order ID 67375

Thursday, March 17, 2011 7:35:22 AM



Page 1

Item ID: D4035-043 Accept  Setup Start 
Revision ID:
Item Name: Lid Rib Assembly, Aft (350 Basket) Stop 
Start Date: 3/17/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 3/24/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: PL Date: 11-03-17 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4035	A								

100 Weld per dwg A/R S.S. rod Batch: 115928 0.00

 Large Fab (6)

Large Fab Memo 0.00

- 1- Cut D4035-3 as per dwg D4035
- 2- Drill holes using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

SAD 11-03-12

PL 11-04-04

110 QC10- Inspect visual per QSI004- ground welds 0.00

 QC (6)

Quality Control Memo 0.00

43

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D4035-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 3/17/2011 Start Qty: 2.00

Required Date: 3/24/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulaylos

(x6)

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD 11-04-05

(6)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/05

MF
11-04-05

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Picklist Print

Thursday, March 17, 2011 7:35:28 AM

Page 1

Work Order ID: 67375

Parent Item: D4035-043

Parent Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 3/17/2011

Required Date: 3/24/2011

Start Qty: 2.00

Required Qty: 2.00



Comments: IPP revA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4021-9		Manufactured	No			100	Each	68.0000	2	<i>* 12</i>			
													
Bushing													

Location	Loc Qty	Loc Code
WA	68	
56094	2	
65363	5	
66437	61	

M304TS0.750W.049		Purchased	No			100	f	224.8708	1.75	<i>12</i>			
													
304 SQ Tube .75x.75x.049W													

Location	Loc Qty	Loc Code
MAT018	224.8707578	
114298	3.6845E-05	
114323	8.15031894	
114677	0.00001	
114835	0.000039	
114992	8.8798	
115260	9.1239	
116319	7.2604	
116509	12.4739	
116719	2.418053	
116788	23.2148	
117029	153.3495	

SAD 11-03-18

End Surap

11.0529 + 1.000 = 12.0529

W/O:		WORK ORDER CHANGES						
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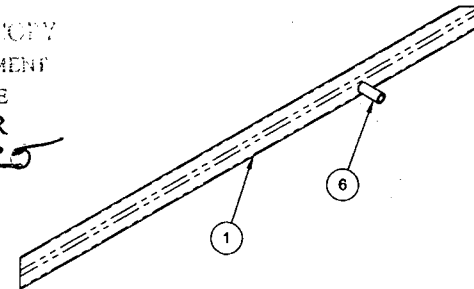
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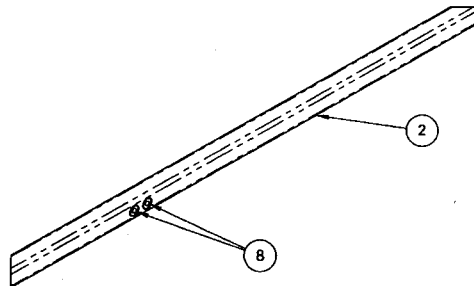
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67325
PH-03-17

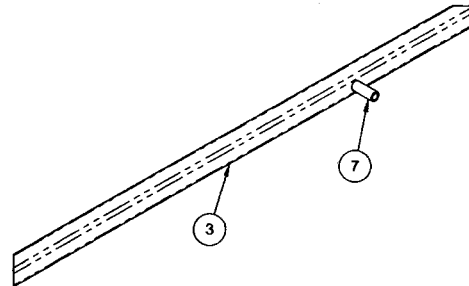


D4035-041 BASKET LID RIB ASSY, FWD

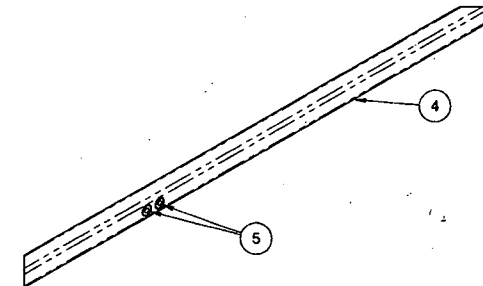
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12
MM

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.04		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4035	REV. A SHEET 1 OF 5
TITLE BASKET LID RIB ASSY	SCALE NTS
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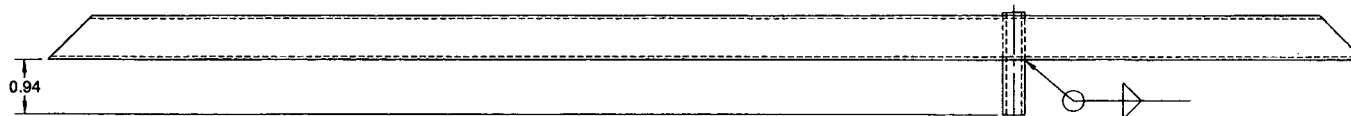
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D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD



D4035-3
RIB

D4021-9
BUSHING
2 PL

G
G
TYP

D4035-043 BASKET LID RIB ASSY, AFT

W1067375

RELEASED
2010-03-12
JW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

D4035-5
RIB

C

C

D2953-175
SPACER

0.94

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

B

B

D4035-7
RIB

WLO 67325

D4035-11
BUSHING
2 PL

G
G
TYP

A

A

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12
AW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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8 7 6 5 4 3 2 1

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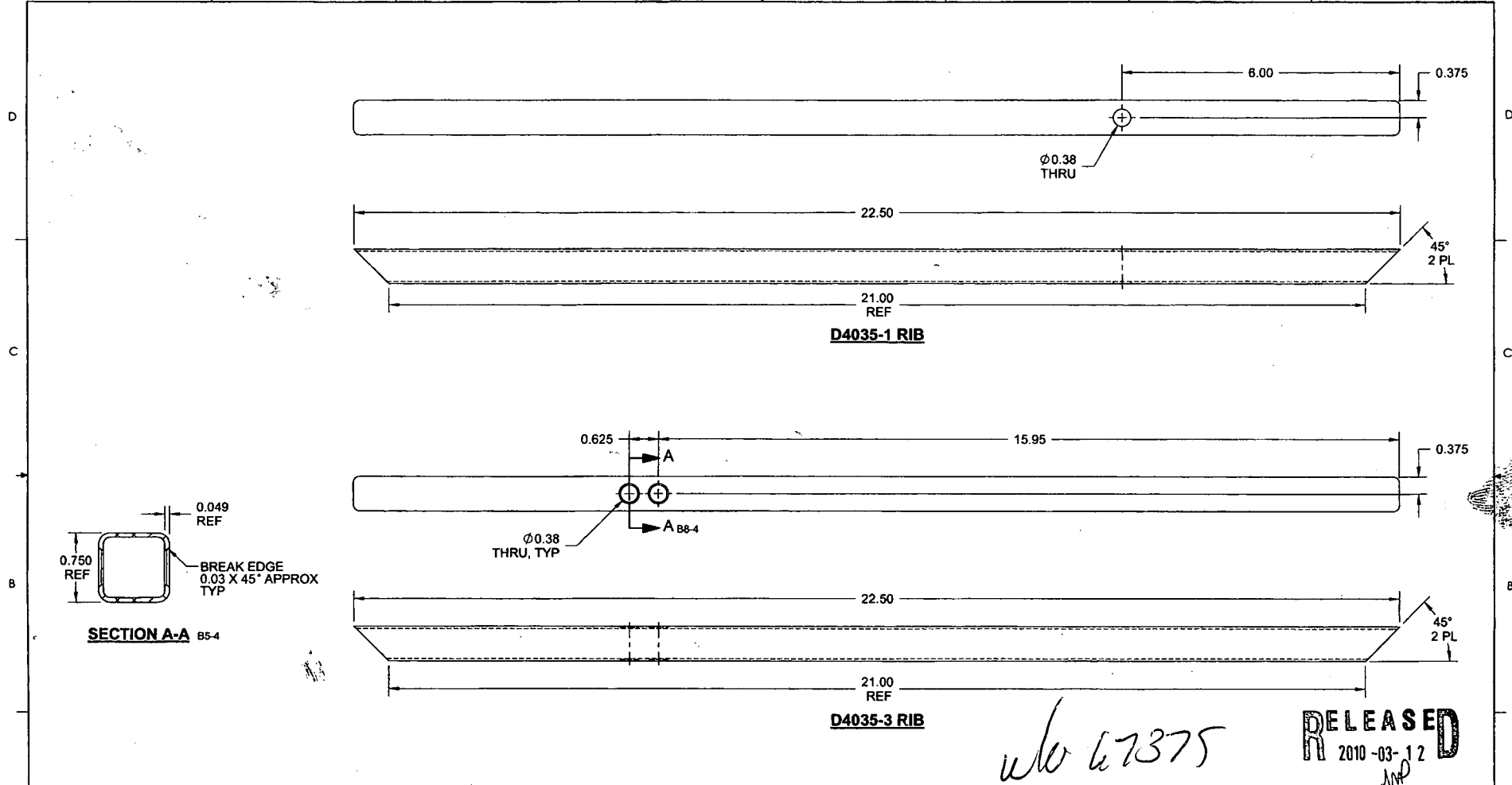
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8 7 6 5 4 3 2 1



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.80 lbs

who 67375

RELEASED
2010-03-12

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4035	REV. A
MFG. APPR.		TITLE	SHEET 4 OF 5
APPROVED		BASKET LID RIB ASSY	SCALE
DE APPR.			NTS
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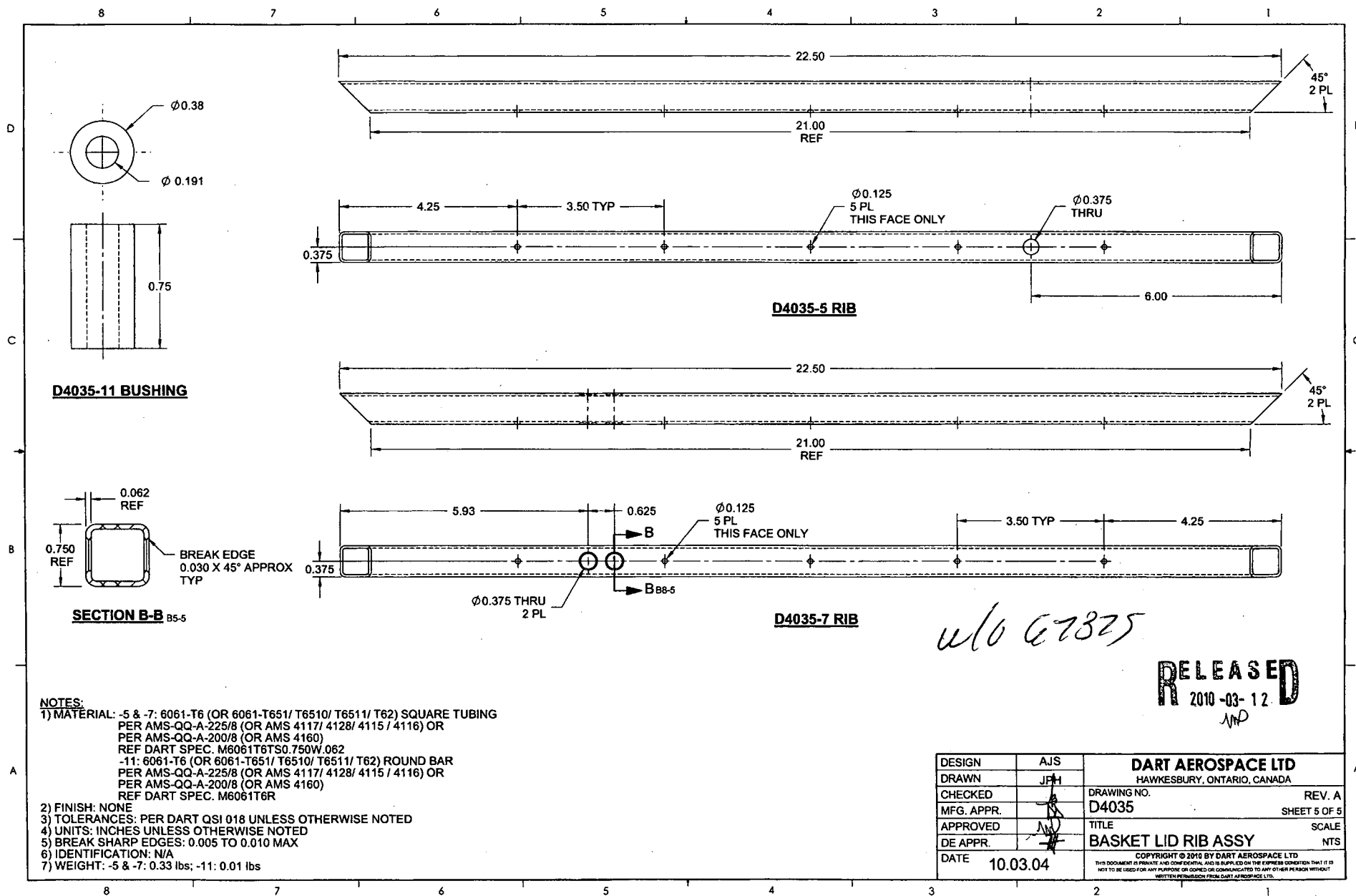
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